

Work Order ID 132491

132491

Page 1

May-07-15 2:47:28 PM

Item ID: D3049-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 5/07/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3049	Rev A1								

110 0.00
110
 Waterjet Memo 0.03
 FLOW CNC Waterjet CUT BLANK AS PER FILE D3049-1_BLANK
8 Ø Jms-5-14

120 0.00
120
 HAAS 1 HAAS CNC VERTICAL MACHINING #1
 HAAS CNC vertical machine #1 Memo 0.05
 1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1
 3-Deburr
8 Ø WSP 15/05/22

130 0.00
130
 QC QC2- Inspect parts off machine FAI/FAIB
 Quality Control Memo 0.00
8 Ø WSP 15/05/22

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8	Ø		DAS 44 9-89 15/05/25
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>SA</u> Packaging Memo	0.00 0.00		PPP132409					MAY 25 2015 DAS 6 9-89
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.01				MLJ			MAY 26 2015 MLJ MAY 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 132491

132491

Parent Item: D3049-1

D3049-1

Parent Item Name: Bearpaw

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10

Purchased

No

120

sf

575.3420

3.4

~~14~~

MUHMWB10

32

Jm15-5-14

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT

519.475

m131661

119.475

m132063

400

132063

MAT018

55.867

m131335

55.867

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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DART AEROSPACE LTD		Work Order: 13249/
Description: Bearpaw		Part Number: D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	0,260	✓		MIP-04	vern
B	0.93	+/-0.030	0,930	✓			
C	0.40	+0.030/-0.000	0,420	✓			
D	2.00	+/-0.030	1,994	✓			
E	10.250	+/-0.010	10,250	✓		CNC-02	vern
F	4.540	+/-0.030	4,540	✓		MIP-04	vern
G	5.88	+/-0.030	5,877	✓			
H	0.38	+/-0.030	0,380	✓			
I	11.50	+/-0.030	11,500	✓		MIP-07	Tape
J	0.07 x 45°	+0.030/-0.010	0,060	✓		MIP-04	vern
K	0.44 - 0.47	+/-0.000	0,460	✓			
L	R0.25	+/-0.030	0,250	✓			Radius gauge
M	0.38	+/-0.010	0,375	✓		118-120	deep throat mic
N	0.95	+0.030/-0.010	0,955	✓		MIP-04	vern
O	0.69	+/-0.030	0,693	✓			
P	0.20	+/-0.030	0,190	✓		MIP-08	Diad depth mic
Q	23.00	+/-0.030	23,00	✓		MIP-07	Tape
R	0.25 x 45°	+/-0.030	0,200 x 45°	✓		MIP-04	vern

Measured by: MIP	Audited by: DAS 44	Prototype Approval:	N/A
Date: 15/05/22	Date: 15/05/25	Date:	N/A

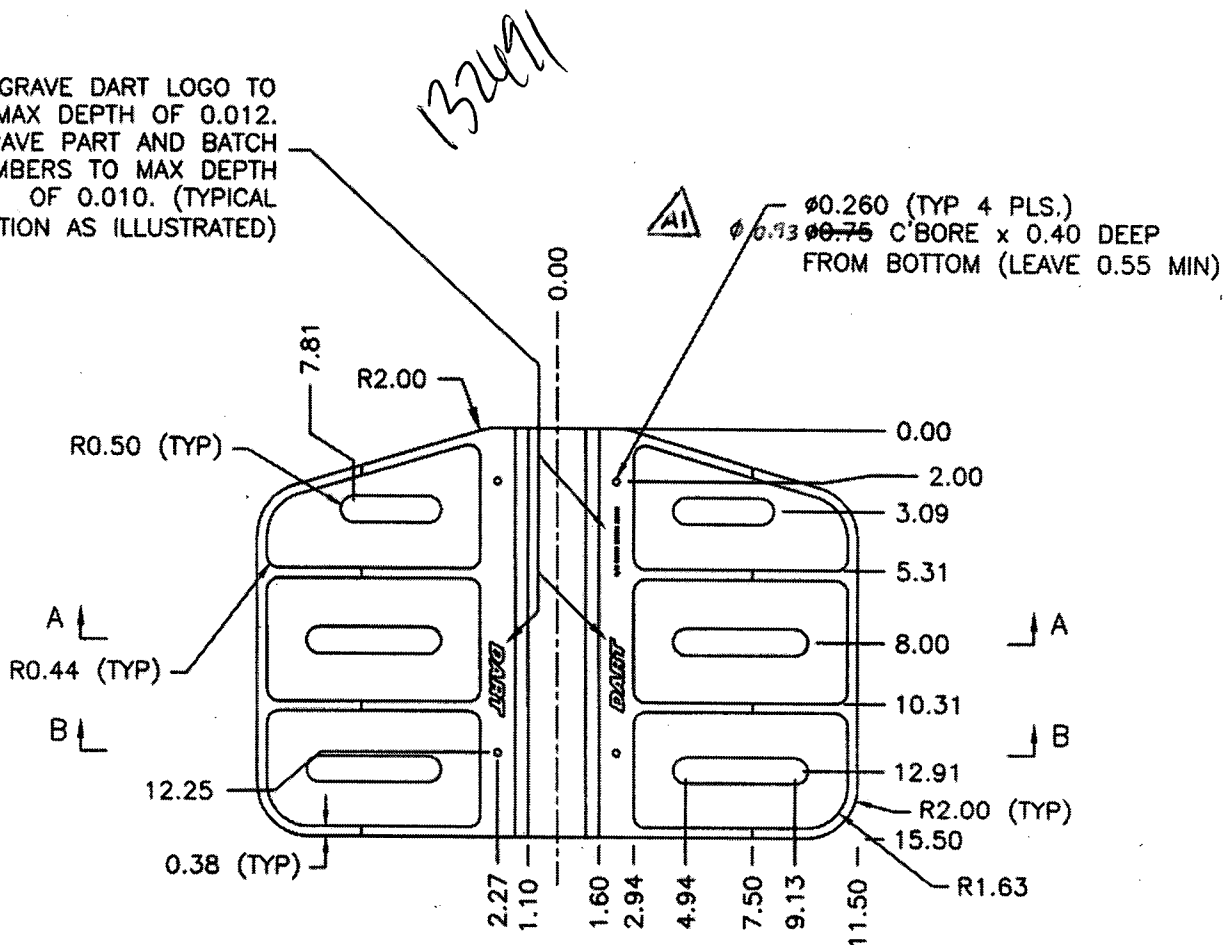
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01.10.18	TITLE BEARPAW		SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	# RF 03.01.13	Ø 0.93 WAS Ø 0.75	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,
1.00" THICK (MACHINE TO 0.950)

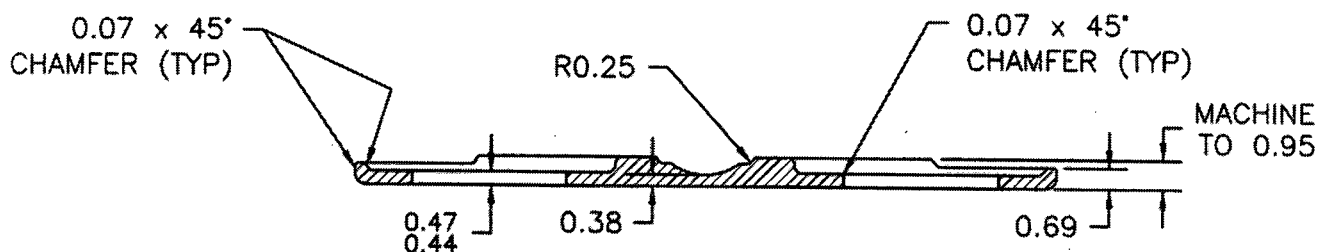
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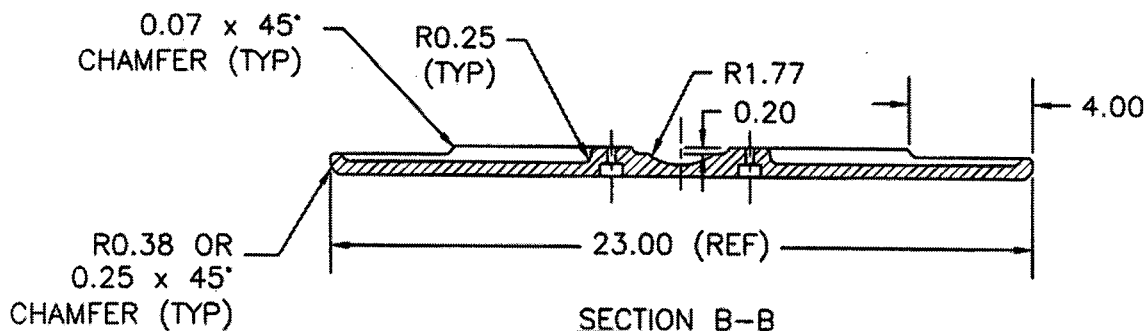


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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SECTION A-A



SECTION B-B

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